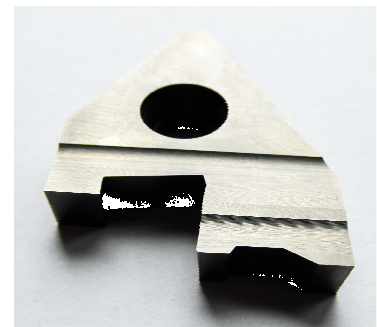
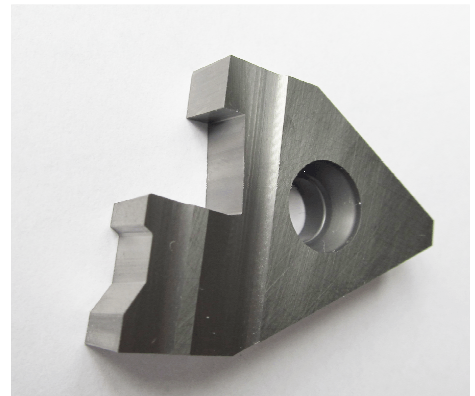


## Turning Insert width 36mm

### A08-010

The rakeform of the double chipbreaker is interpolated while oscillating along the length of blank to achieve a straight bottom line. 2 pregrinding passes are roughing the profile with passes of 2 mm. The 3 pregrind process prepares the the profile for the final finishing pass with overmeasure of 0.06 mm. The Insert is clamped in an adapted cartridge corresponding to the V-reference faces of the blank. If the references are not ground, a TTC clamping can be recommended allowing to grind around the insert: profile, chipbreaker as well as reference faces.



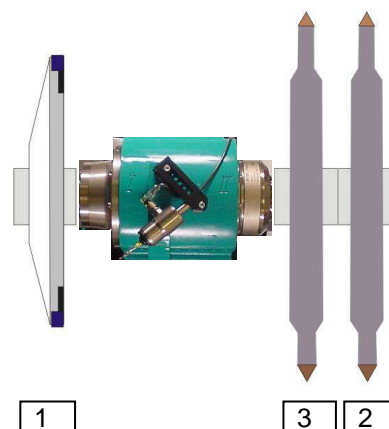
### 1. Cycletime for Production

Workpiece: B 36 mm, T 6 mm Material CARBIDE						
Operations						
	Chipbreaker	Chipbreaker 2	Pregrind 1	Pregrind 2	Pregrind 3	Finishing
Feed [mm/Min]	500	500	25	25	40	60
Power [kW]	1	1	4	3	2	2
Cutting speed [m/s]	22	22	22	22	22	22
Used wheels						
	1	1	2	2	2	3
Grinding time [s]	47	47	285	318	125	120
Total cycle time	15 Min 43					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14V1 Ø300 D64V40°
3	14V1 Ø300 D46V40°



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 31iA5

Accessories:

Responsible engineer: OP. 3.7.12

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China